



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3212-1
Job Sheet 178563



Part No: D3212-1

Job Qty: 4 ea

Part Name: Replacement Interior Window For -015 & -025



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev: A New Issue 05-11-09 JLM IPP Rev: B Water jet/ ecn798 06-05-08 EC IPP rev.C back on haas 07.04.09 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Waterjet		SC 18/06/15
100	Waterjet	4 pcs	6/22/18	6/22/18	0.00	0.22	Waterjet1		SC 18/06/15
110	CNC Vertical Machining	4 pcs	6/22/18	6/22/18	0.29	0.96	HAAS1-3		DJP 18/08/11
120	QC	4 pcs	6/22/18	6/22/18	0.00	0.00	QC2 Machining-2		DJP 18/08/11
130	QC	4 pcs	6/22/18	6/22/18	0.00	0.00	QC8 Machining-2		marc 18/08/11
140	Small Fab	4 pcs	6/22/18	6/22/18	0.00	0.94	Small Fab-3		DAS
150	QC	4 pcs	6/22/18	6/22/18	0.00	0.00	QC5		DAS AUG 28 2018 68
160	Packaging	4 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-1		AUG 31 2018
170	QC21-SA	4 Ea	6/22/18	6/22/18	0.00	0.00	QC21		AUG 31 2018

Part Op 100 - 1-Cut blankas per Dwg D3212, Machine per Folio FA349 and dwg D3212

Descriptions: 140 - 1-Deburr if necessary 2-Install label as per Dwg D3212 3- polish abrasion scratches if necessary.. 4-Wrap in plastic wrap after inspection

- 22

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2728-1	Dart Logo Label Small	4 Ea (1 ea)	90-Start up Operation	
MACRLICS.125	1/8" Polycast li Sheet	3.9980 sf (.9745 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2728-1	4	0	0
140-Small Fab	MACRLICS.125	4	2,011	0

Part Specifications

Specifications could not be found.

Plex 6/1/18 2:54 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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DART AEROSPACE LTD		Work Order:	178563
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.738	✓		H.G.	
6.367	+/-0.005	6.366	✓		H.G.	
0.625	+/-0.005	0.628	✓		H.G.	
Ø0.156	+0.005/-0.001	0.1565	✓		Gage Pin	
R0.25	+/-0.030	0.250	✓		R. Gage	
8.150	+/-0.005	8.150	✓		H.G.	
3.750	+/-0.005	3.749	✓		H.G.	
0.313	+/-0.010	0.319	✓		H.G.	
15.14	+/-0.030	15.150	✓		H.G.	
12.520	+/-0.005	12.518	✓		H.G.	
6.260	+/-0.005	6.259	✓		H.G.	
1.312	+/-0.005	1.3165	✓		H.G.	
0.313	+/-0.010	0.3165	✓		H.G.	
3.750	+/-0.005	3.749	✓		H.G.	
8.150	+/-0.005	8.151	✓		H.G.	
8.462	+/-0.005	8.4635	✓		H.G.	
9.09	+/-0.030	9.092	✓		H.G.	

Measured by: <i>SC</i>	Audited by: <i>mmc</i>	Preliminary Approval:
Date: 18/06/15	Date: 18/18/24	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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